

MACHINING INSTRUCTIONS FOR CONVERTING THE DURCO 6" GRP I BACK COVER/SEAL CHAMBER FOR USE ON THE FRAME S

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Form
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Section	Forms
Effective	Oct. 2004
Replaces	ASD 131

Parts needed

Hardware Conversion Kit No. 99698

- Includes:
- (2) 10-24 Studs
 - (2) 10-24 Nuts
 - (4) 3/8-16 Regular Hex Nuts
 - (4) 3/8 D-Shaped Washers

Newer Durco 6" GRP I Back Cover/Seal Chambers have been modified to eliminate some machining operations when converting it for use on Frame S. Two 10-24 UNC tapped holes for use when mounting the Back Cover/Seal Chamber to the Frame S frame adapter have been added. A raised O-ring surface (45 RMS) has been extended out to a 3.00 diameter to leave a sealing surface after boring the Back Cover/Seal Chamber out to 2.38 diameter for -12 seals.

The original design must have these (2) 10-24 tapped holes machined to mount onto the Frame S frame adapter and be faced off to provide and adequate sealing surface.

NEW VERSION

1. Remove the (6) 3/8-16 studs.
2. Bore out the Back Cover/Seal Chamber to 2.38 diameter .09 deep, then machine 25° angle.
3. Bore out the bottom of the Back Cover/Seal Chamber from 1.91 diameter to 2.38 diameter to existing depth and from 1.19 diameter to a 1.520 diameter.
4. Install the (2) 10-24 studs and (4) 3/8-16 seal chamber gland studs.

OLD VERSION

1. Remove the (6) 3/8-16 studs.
2. Drill and tap the (2) 10-24 UNC holes as shown, deburr surface.
3. Face off the gasket surface to a 2.24 height leaving (45 RMS) out to a 3.00 diameter. Step down .005 and finish top of Back Cover/Seal Chamber to leave a raised flange.
4. Bore out the Back Cover/Seal Chamber to 2.38 diameter .09 deep, then machine 25° angle.
5. Bore out the bottom of the Back Cover/Seal Chamber from 1.91 diameter to 2.38 diameter, 2.09 deep and bore out the 1.19 diameter to 1.520 diameter.
6. Install the (2) 10-24 studs and (4) 3/8-16 seal chamber gland studs.



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